

Work Order ID 65192

Friday, January 07, 2011 10:40:40 AM



Page 1

Item ID: D3508-3

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 1/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:



Date: 1/7/2011

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3508	Rev C

100



FLOW WATER JET

Waterjet

Memo

0.00

R11-1-10

FLOW CNC Waterjet

364.040

I-Cut as per Dwg D3508

 Dwg Rev: C Prog Rev: C 2-

Deburr if necessary

(6)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

R11-1-10

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

S.110110

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65192

Friday, January 07, 2011 10:40:40 AM



Page 2

Item ID: D3508-3

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 1/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

0.00



Brake NC

Memo

0.00

Brake NC

1-Form on brake using DT8326 and DT8261as per Dwg D3508 2-Form joggle
as per Dwg D3508 Using DT8158

SB 11/01/11

140



QC5- Inspect part completeness to step on W/O

0.00

S. Balaji

QC

Memo

0.00

Quality Control

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



M112588

Powdercoat

Memo

0.00

Powder Coating

START TIME: 1:25OVEN TEMPERATURE: 300FINISH TIME: 1:05

6 bl 11-01-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65192

Page 3

Friday, January 07, 2011 10:40:40 AM

Item ID: D3508-3

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 1/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

160



QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

X6 0 11/01/12

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: F P-2

0.00

X6 0 11/01/12

Memo

0.00

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/01/12 JH

MF
11-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, January 07, 2011 10:40:44 AM

Page 1

Work Order ID: 65192



Parent Item: D3508-3



Parent Item Name: Wearplate

Start Date: 1/7/2011

Required Date: 1/14/2011

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:A New Issue 06-06-20 JLM
IPP Rev:B Now SS as per Rev B 06-12-15 JLM
IPP Rev:C Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	181.0714	0.734	4.635789		 1811-1-10	

304/316 .040 Sheet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	178.3	
115762	10.2	
115953	11.1	
116437	157	116437
MAT20	2.7714	
113062	1.398	
115440	1.3734	

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	CS192
Description: Wearplate	Part Number:	D3508-3
Inspection Dwg: D3508	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	R	Audited by:	S	Prototype Approval:	N/A
Date:	11-10-10	Date:	11-10-10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	

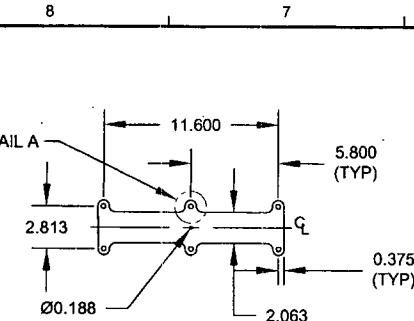
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

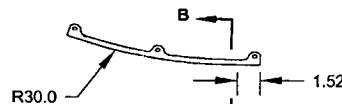
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

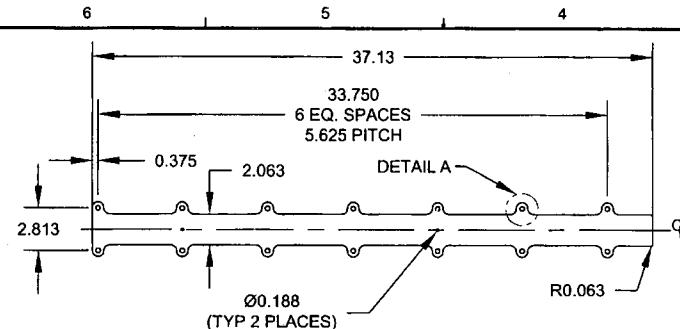
NOTE: Date & initial all entries



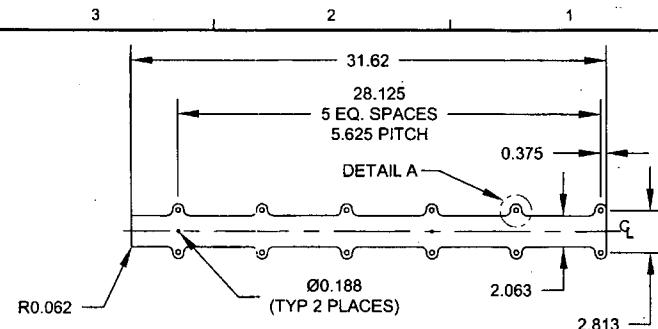
D3508-1 FLAT PATTERN



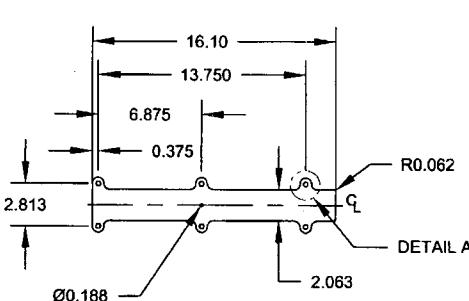
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



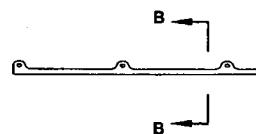
D3508-3 FLAT PATTERN



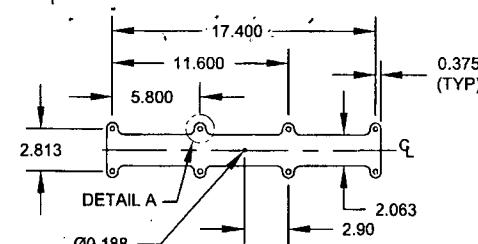
D3508-5 FLAT PATTERN



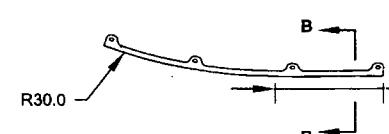
D3508-7F FLAT PATTERN



D3508-7F BENDING DETAIL
(MAKE FROM D3508-7F)



D3508-9F FLAT PATTERN



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs
D3508-13 - 0.25 lbs

RELEASED
07/11/16

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65192

PL 11-08-7

C	ADD -9/11-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	74	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	24	DRAWING NO.	REV. C
CHECKED	NP	D3508	SHEET 1 OF 2
MFG. APPR.	IG	TITLE	SCALE
APPROVED	NP	WEARPLATE	1:8
DE APPR.	NP	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OTHER THAN THAT FOR WHICH IT WAS PROVIDED. NO OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	
DATE	07.04.20		

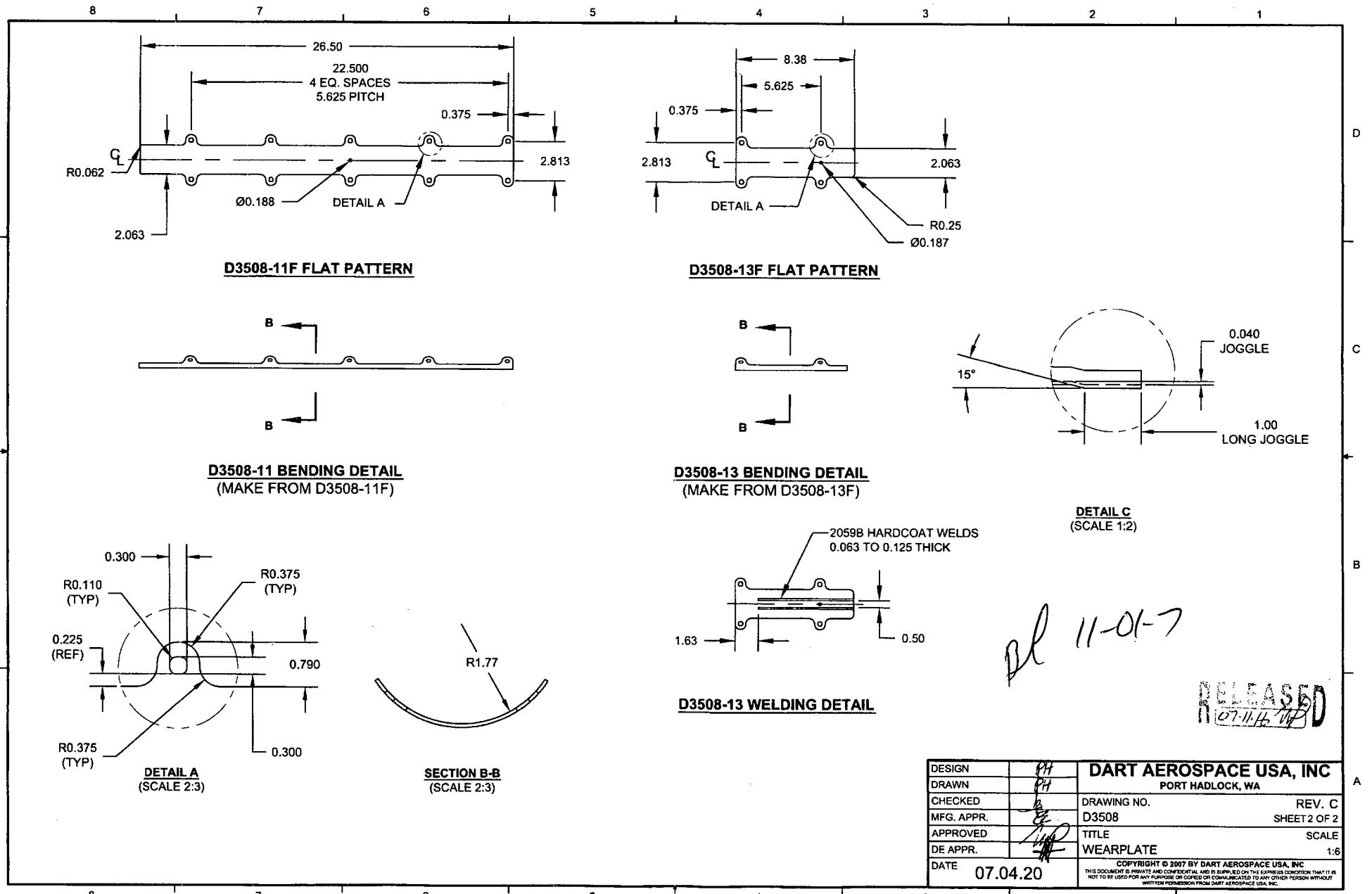
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries